

Work Order ID 91273

October-05-12 9:15:41 AM

91273

Page 1

Item ID: 647.4712

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Doubler

Stop ***NS2***

Start Date: 10/05/12 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-10-05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.4700

N/C

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A/C

Prog Rev: A/C

2-Deburr if necessary

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

15 0 JM 12-10-14

15 0 JM 12-10-14

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Page 2

Item ID: 647.4712

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Doubler

Stop ***NS2***

Start Date: 10/05/12 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

October-05-12 9:15:41 AM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

0.00

0.00

0.00

PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

CARDINAL 4860-50 PRIMER BATCH: 123693

0.00

0.00

7

Work Order ID 91273

October-05-12 9:15:41 AM

91273

Page 4

Item ID: 647.4712 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 10/05/12 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 10/31/12 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location 439A Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** DAS 12/11/20 05 9-89	0.00 0.00							12/11/21 (15)
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/11/22 ME 12-11-20

Picklist Print

October-05-12 9:15:40 AM

Page 1

Work Order ID: 91273

Parent Item: 647.4712

Parent Item Name: Doubler

Start Date: 10/05/12

Required Date: 10/31/12

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.09.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

2024-T3 .050 sheet

Purchased

No

110

sf

203.8484

0.825

~~13.026316~~
13.5

Jm 12-10-14

Location

Loc Qty

Loc Code

MAT022

203.8484204

117684

17.8

121216

71.4484204

121889

114.6

121216

NOTES: UNLESS OTHERWISE SPECIFIED

2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N

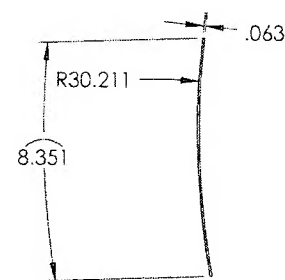
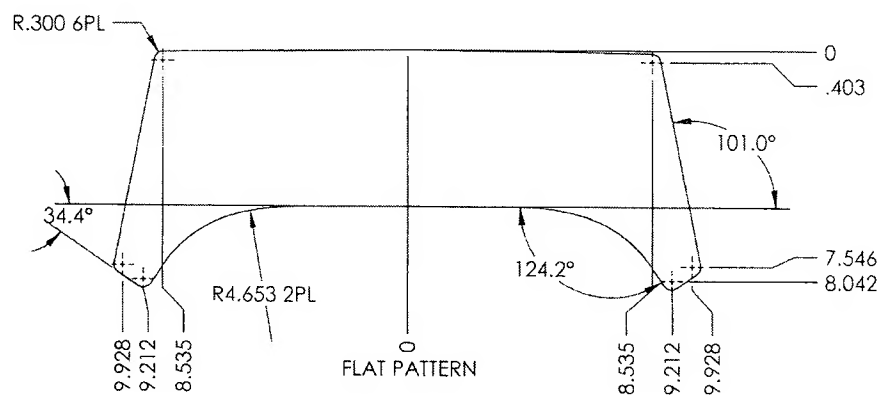
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
WITHOUT NOTICE

WORK ORDER

NO. 91273 MLT

12-10-05

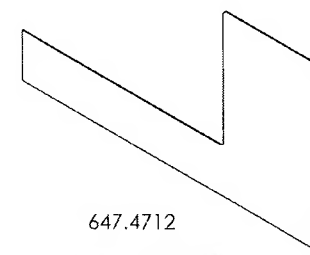


			1	647.4719	CLIP FWD		△	△
			1	647.4718	CLIP AFT RH		△	△
			1	647.4717	CLIP AFT LH		△	△
			1	647.4716	SPACER		△	△
			1	647.4715	CLIP RH		△	△
			1	647.4714	CLIP LH		△	△
			1	647.4713	BACKET		△	△
			1	647.4712	DOUBLER		△	△
			1	647.4711	DOUBLER		△	△
				PART #			MAT'L	SPEC.
QTY		PARTS LIST						
NEXT ASSY (S):		APICAL INDUSTRIES						
647.2600		2608 TEMPLE HEIGHTS DR OCEANSIDE, CA. 92056-3512 (760)724-5300						
		SHEETMETAL						
		CONFIGURATION INDICATED BY DIMENSIONS DRAWING APPROVAL:  DATE: _____ CHECKED BY: _____ CONTRACT NO.: _____ MATERIAL OBSERVED: SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1/16" DECIMALS ± .005 1/32" DECIMALS ± .003 1/64" DECIMALS ± .003						
		MATERIAL		SCALE		DWG NO		REV
		NONE		1/8" = 1"		647.4700		NONE
		SCALE		NONE		1 SHEET		1 OF 7

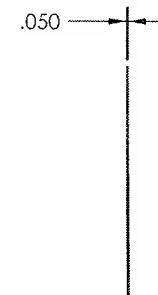
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REV		DESCRIPTION	DATE	APPROVED

91273

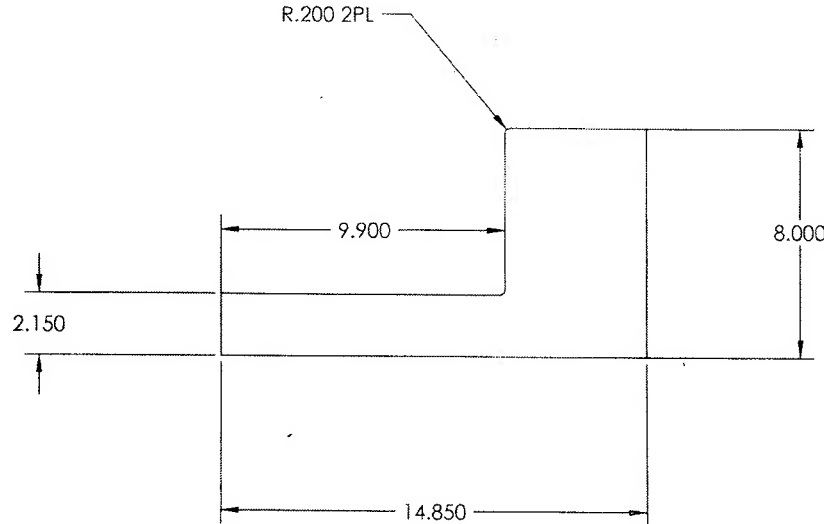


647.4712



0.050

R.200 2PL



2.150

9.900

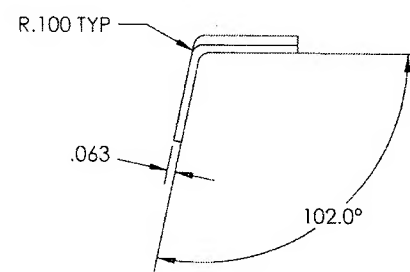
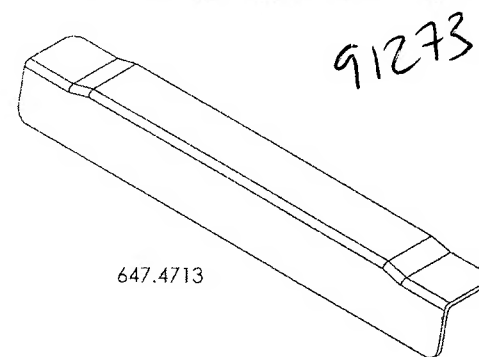
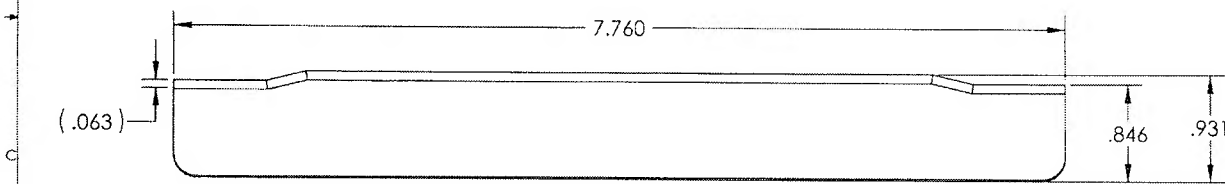
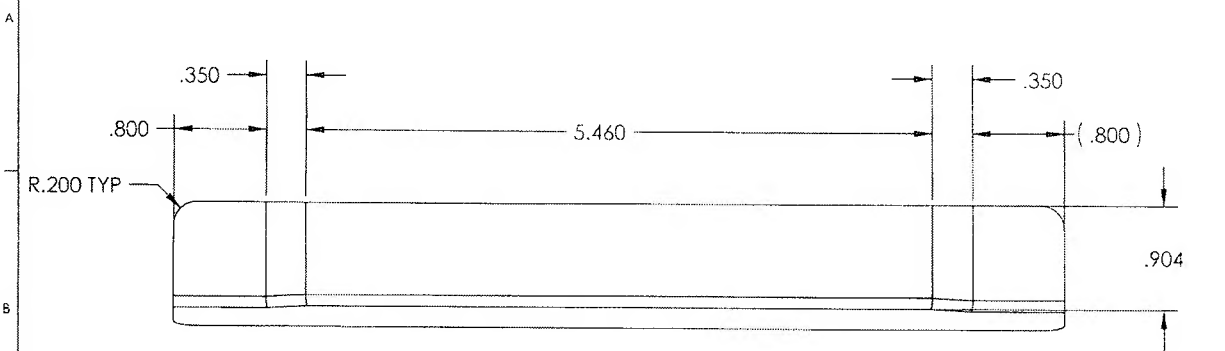
8.000

14.850

ORIGINAL DATE AND QUANTITY DRAWN BY A. CLARK DRAWING APPROVAL E. BAYLER CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92036-3312 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE FRACTIONS 3 PLACES DECIMALS 0.000 ANGLES 1/2°		SHEETMETAL Dwg No. 647.4700 SCALE: NONE	
REV	CAGE CODE	DWG NO.	REV.
B	07M16	647.4700	NAC
SCALE: NONE		SHEET 2 OF 7	

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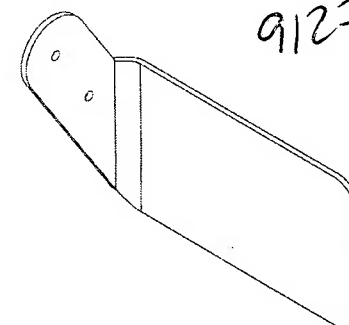
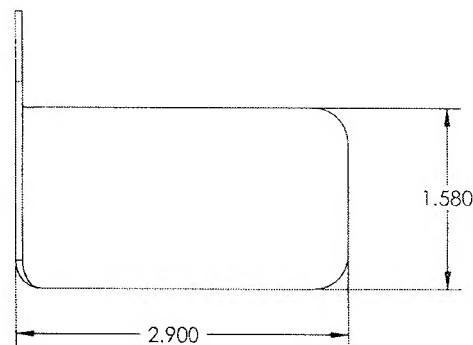
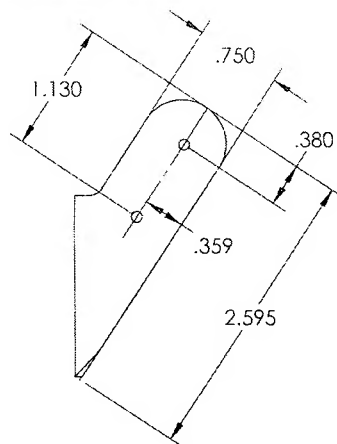
REV	DESCRIPTION	DATE	APPROVED



OFFICIAL DATE 10/12/09	APICAL INDUSTRIES		
DESIGNED BY A. QUINN	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWING APPROVAL P. BRADY	SHEETMETAL		
CONTRACT NO.	REV. B	QTY. NO. 647.4700	REV. HMC
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ± .01 DECIMALS ± .005 ANGLES ± .5°		SCALE NONE	SHEET 3 OF 7

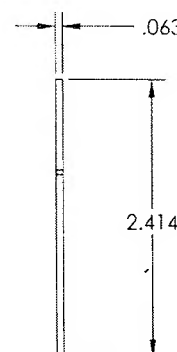
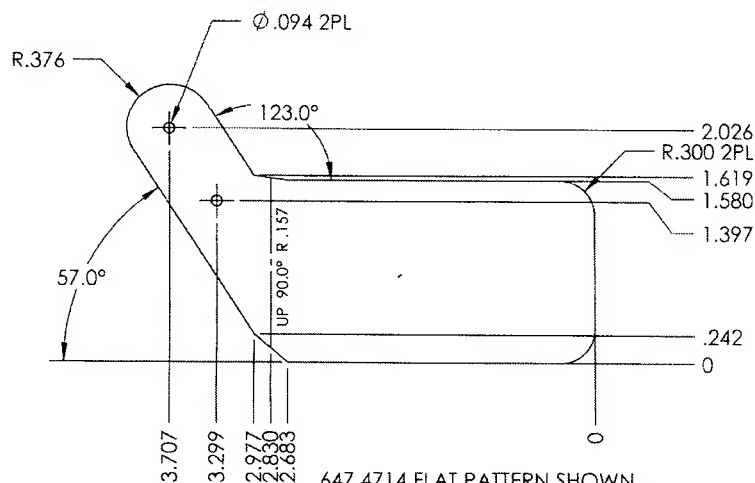
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REV	DESCRIPTION	DATE	APPROVED



91273

647.4714 SHOWN
647.4715 OPPOSITE



647.4714 FLAT PATTERN SHOWN
647.4715 BEND DOWN

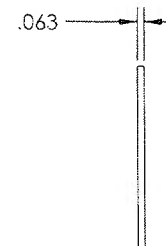
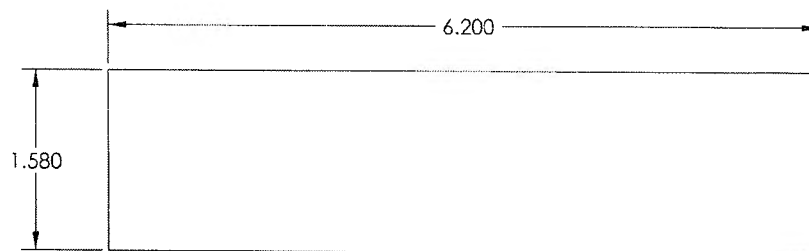
ORIGINAL DATE 10/10/00 DRAWN BY A. GUAN CHECKED BY D. BARKER DRAWING APPROVAL 10/10/00 CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE: FRACTIONS DECIMALS 1/16" DECIMALS 2.000 ANGLES 1/2°	SHEET CODES 8 07M26 DWG NO. 647.4700 SCALE NONE SHEET 4 OF 7

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REVISIONS			
REV	DATE	BY	APPROVED
1			
2			
3			

91273

647.4716

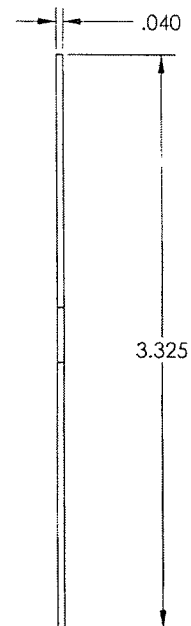
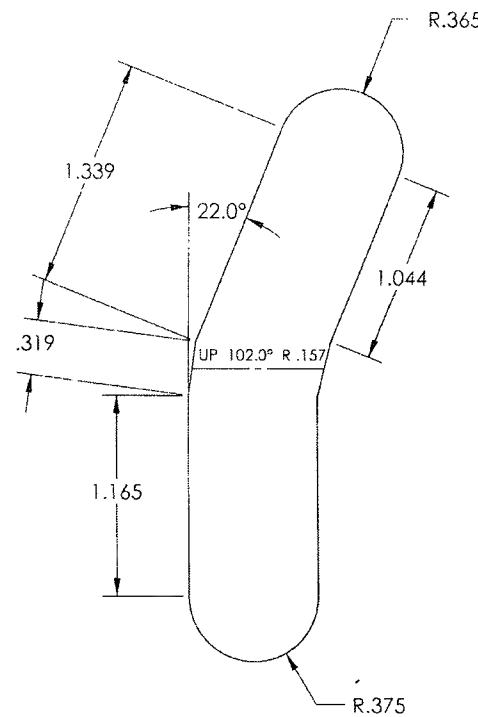
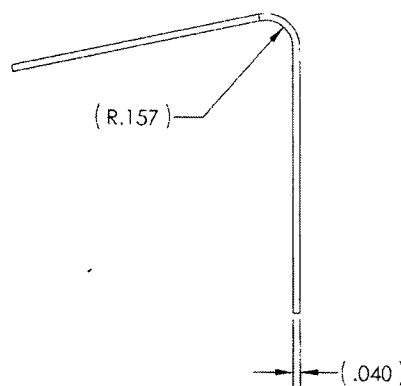
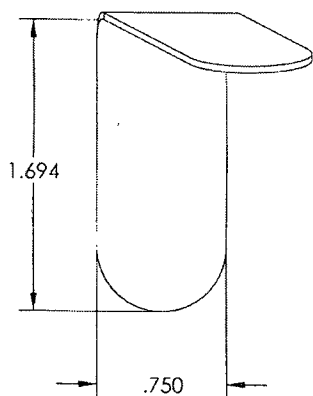
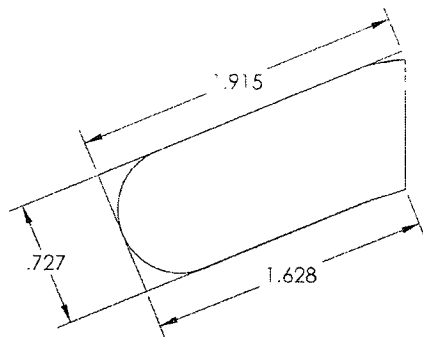
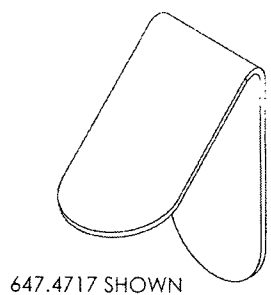


OPERATOR DATE: 10/13/09 MODEL: 171 DIRECTION: 171 A. QUANT: 10 849119 DRAWING APPROVAL: BY: 171 DATE: 10/13/09 COMMENTS:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1/16" DECIMALS ±.015 1/32" DECIMALS ±.010 ANGLES ±.5°		SHEET CODE: B DATE: 10/13/09 SCALE: NONE	DWG NO: 647.4700 REV: N/C SHEET 5 OF 7

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REV	DESCRIPTION	DATE	APPROVED

91273



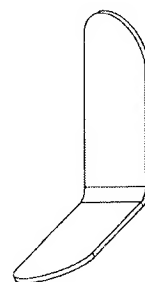
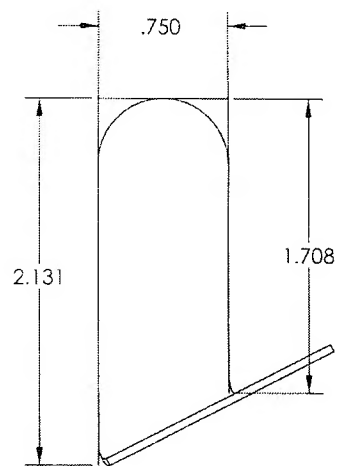
647.4717 FLAT PATTERN SHOWN
647.4718 BEND DOWN

C. P. 000000 DATE: 01/13/00		APICAL INDUSTRIES	
DRAWN BY: A. C. 000000		2608 TEMPLE HEIGHTS CR.	
CHECKED BY: J. B. 000000		OCEANSIDE, CA. 92056-3512 (760)724-5300	
APPROVED BY: J. B. 000000		SHEETMETAL	
C. P. 000000		SHEET 6 OF 7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .001 ANGLES ± .5°		SHEET 6 OF 7	

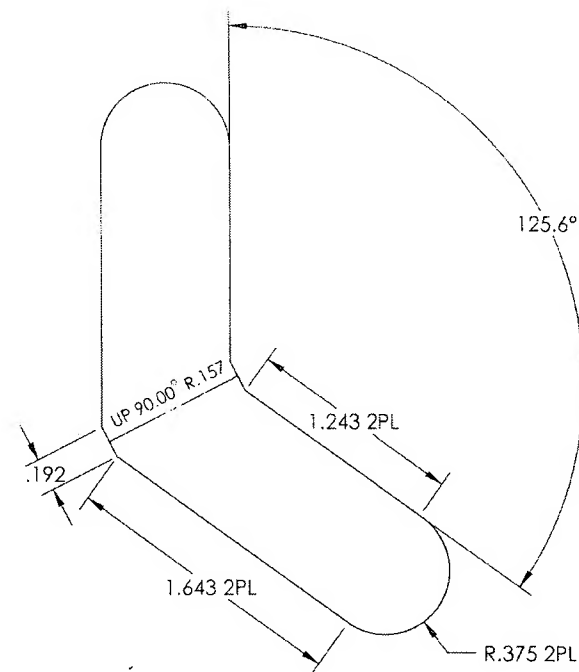
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REV	DESCRIPTION	DATE	APPROVED

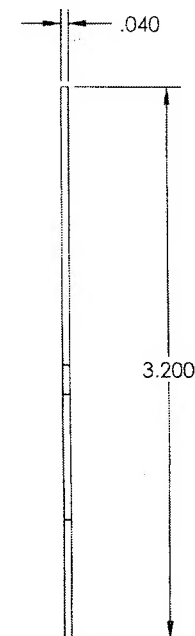
91273



647.4719



647.4719 FLAT PATTERN



ORIGINAL DATE (JACOBI) 10-13-09	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3512 (760)724-5300		
DESIGNED BY A. QUINN	CHECKED BY D. BURKE		
QUANTITY APPROVAL P. BRAY			
CONTRACT NO.	SHEETMETAL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			
REV B	DATE 07/21/16	QTY 647.4700	REV N/C
SCALE: NONE		SHEET 7 OF 7	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.9813 10 PCS 646.9811 10 PCS 646.9812 10 PCS 646.9812 2 PCS 646.9811 15 PCS 646.4711 15 PCS 647.4716 15 PCS 647.4712 15 PCS 647.4717 15 PCS 647.4714 15 PCS 647.4715 15 PCS 647.4718 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120674	Rev:	PO: PO18153 Line:
1 lot	Part: ASST 7 PCS 647.1810 14 PCS 647.1811 91 PCS 647.1812 2 PCS 647.1612 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120673	Rev:	PO: PO18304 Line:
Certificate of Conformance			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.	
	ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY	
	DATE : <u>5/11/12</u>	
	CERTIFIED SIGNATURE : <u></u>	
	RECEIVER SIGNATURE : _____	